

Work Order ID 68728

Monday, May 09, 2011 9:17:33 AM



Page 1

Item ID: D3016-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Frame Assembly

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

DUPLICATE

Reference:

Run Start

Approvals: Process Plan: UMFDate: 11-05-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3016

RevA / DEO A-1

100

Weld per dwg A/R 4130 rod Batch: 11114509 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig
DT8597

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

5- Assemble brackets and gusset per dwg and weld

EL 11-5-16 (X1)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/05/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name:	Seat Frame Assembly					
Start Date:	4/20/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/25/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>8 11/05/11</i>		<i>XLscr</i>			
130 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M115 128.</i> Memo Install paint screws on fitting ends START TIME: <i>1:30</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>2:00.</i>	0.00 0.00						<i>1 BR 11-5-17.</i>	
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>1 8 11/05/11</i>	

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location:

GA

0.00

Memo

w/p 69116

0.00

4/5/05/18 @

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/18

11-05-18
①

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Picklist Print

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Page 1

Work Order ID: 68728

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly





Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 01.09.19 New issue EC IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.049  4130 RD Tube .750 x.049W		Purchased	No			100	f	33.4900	4.3	4.526316			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		33.49							
				110740		33.49							
M4130NT0.500W.049  4130 RD Tube .500 x.049W		Purchased	No			100	f	63.5500	4.3	4.526316			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT032		63.55							
				110740		63.55							
M4130NT1.000W.120  4130 RD Tube 1.00 x .120wall		Purchased	No			100	f	5.8000	1.5	1.578947			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		5.8							
				117372		5.8							
D3016-17  Gusset		Manufactured	No			100	Each	8.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA019		8							
				68736		8							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 68728



Parent Item: D3016-041



Parent Item Name: Seat Frame Assembly

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3016-13 Manufactured No

100 Each

6.0000 2 2



Bracket



EL 11-5-17

Location

Loc Qty

Loc Code

WA019

6

44778

6

D3016-15 Manufactured No

100 Each

10.0000 2 2



Gusset



EL 11-5-17

Location

Loc Qty

Loc Code

WA019

10

68735

10

D3020-1 Manufactured No

100 Each

17.0000 4 4



Fitting



EL 11-5-16

Location

Loc Qty

Loc Code

WA

17

36713

17

4

Monday, May 09, 2011 9:17:31 AM

Shop Packet Print

Page 2

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

68728

DEO ATTACHED

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01.05.30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

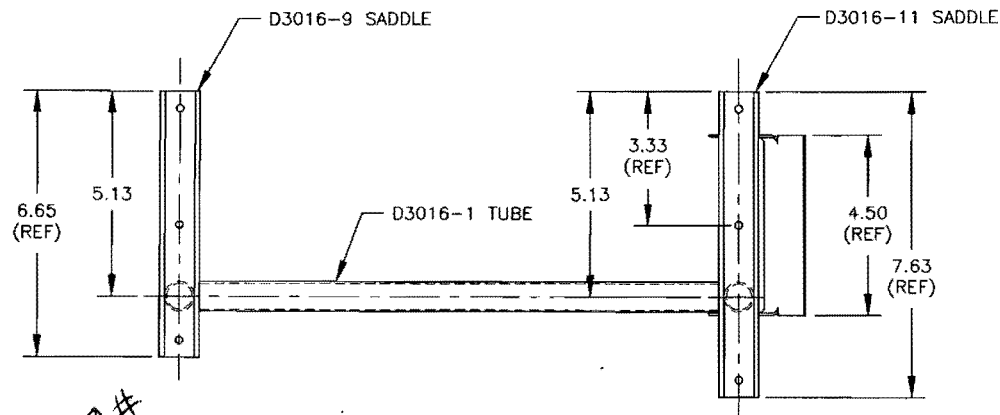
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

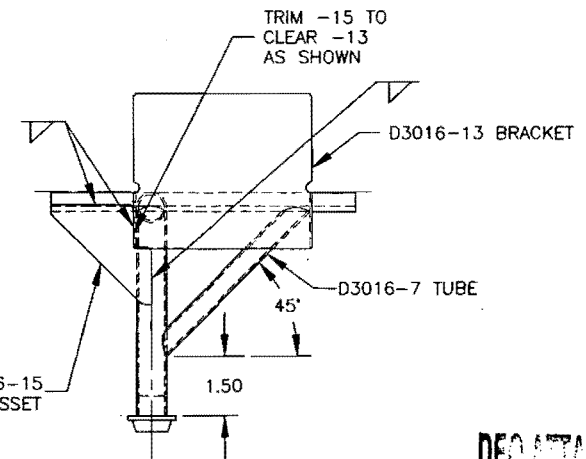
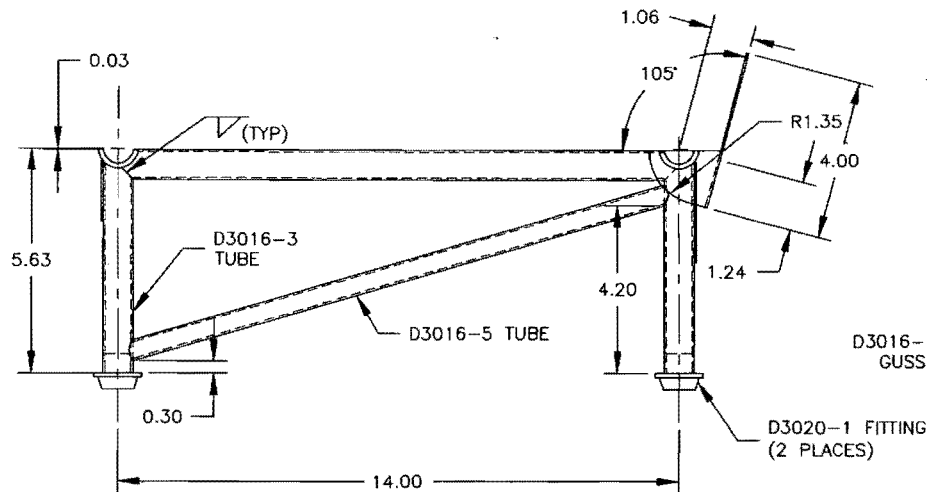
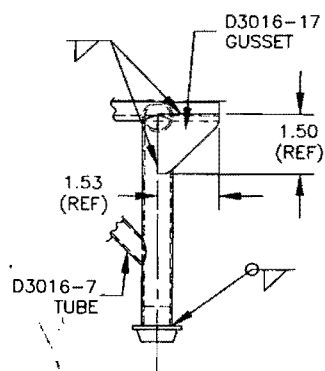
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D3016-041 SEAT FRAME ASSEMBLY



80689#



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01.05.30

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	CHECKED	APPROVED			DRAWING NO.
	DATE	TITLE	D3016		SHEET 2 OF 3
	01.05.18	SEAT FRAME ASSEMBLY			SCALE
					1:3

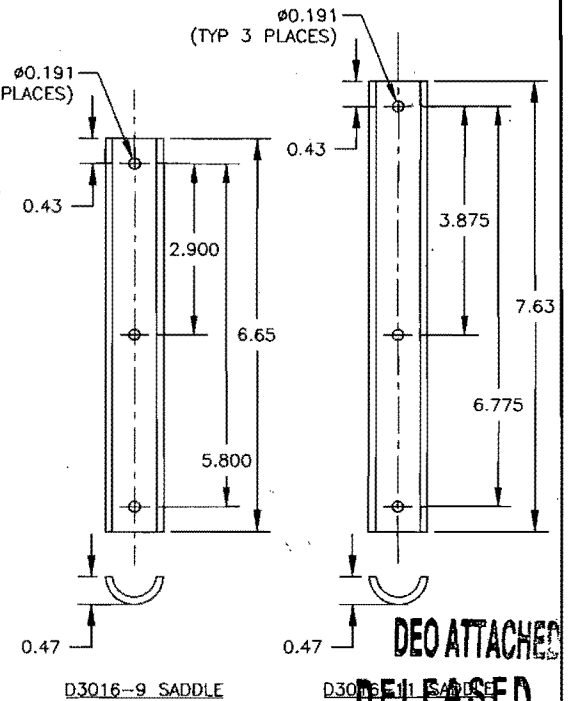
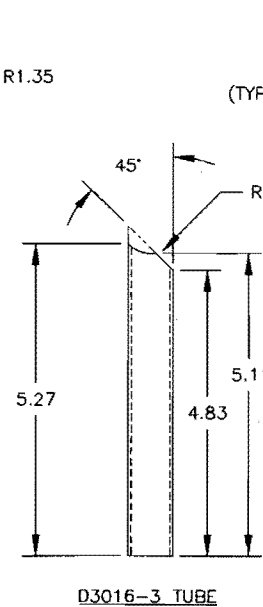
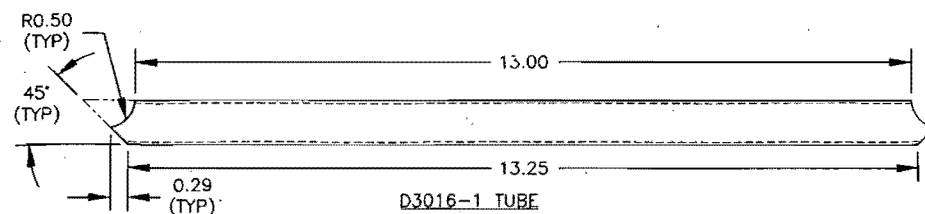
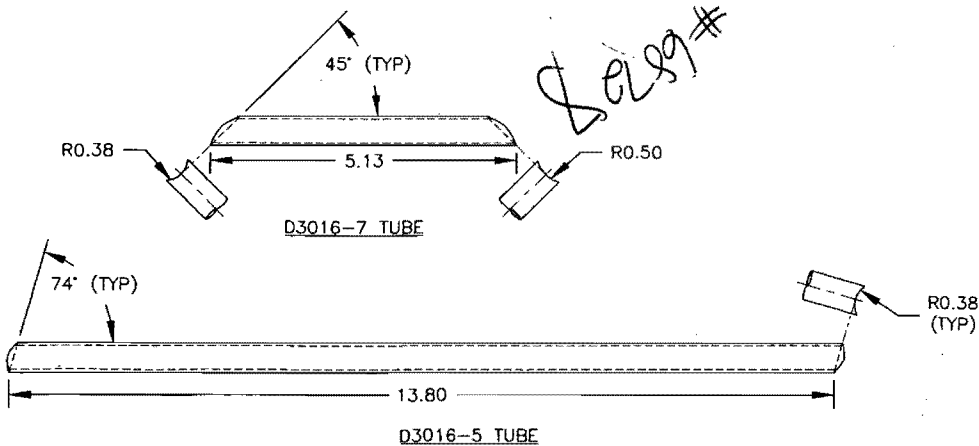
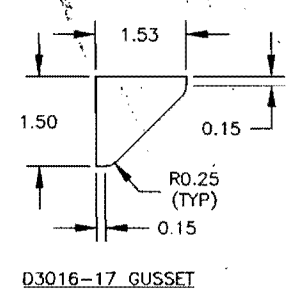
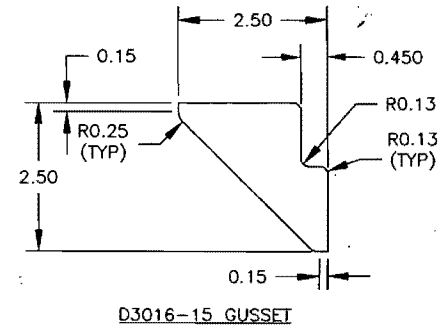
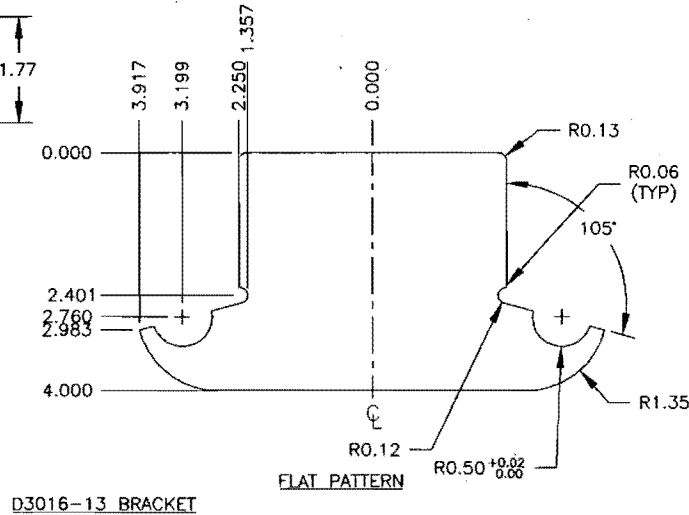
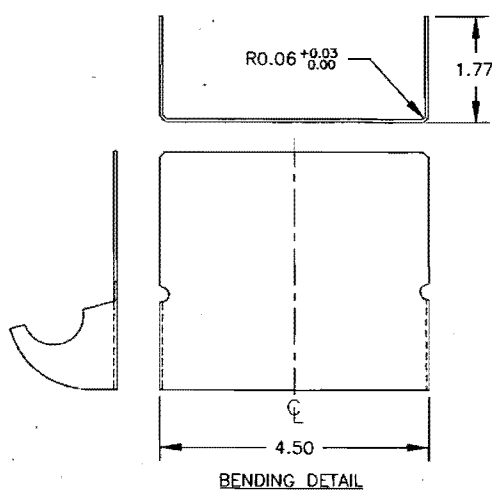
W/O:		WORK ORDER CHANGES					
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DESIGN	UP	DRAWN BY	UP	DART	DART AEROSPACE LTD. WARRIMUR, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3016	REV. A SHEET 3 OF 3
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	SCALE	1:2

W/O:		WORK ORDER CHANGES					
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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>WAP</i>	DE APPR. <i>TH</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		

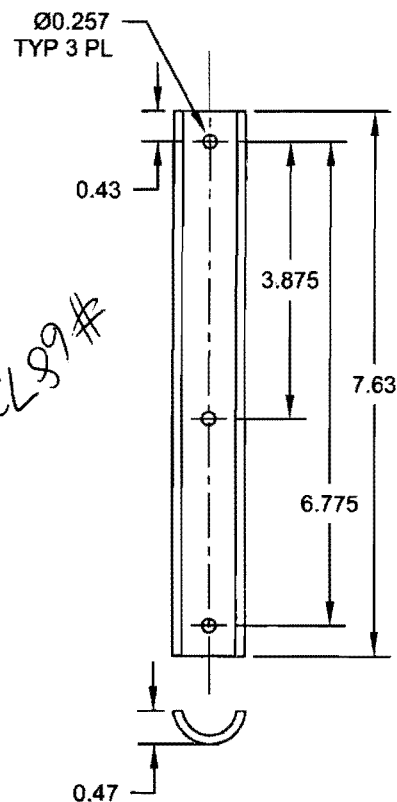
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

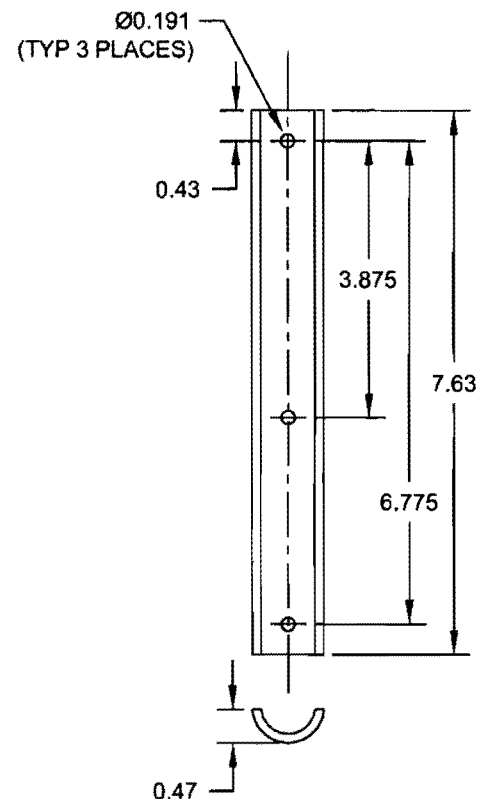
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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